

**WHAT IS CLAIMED IS:**

1. A mold with form keys for forming a reverse draft in a thermoformed part, comprising:

- a mold, said mold including a male plug, said male plug including a female form  
 5 key and an first fluid driven actuator for actuating said female form key,  
 said mold including a female cavity, said female cavity including a male form key  
 and a second fluid driven actuator for actuating said male form key.

2. The mold claimed in claim 1 further comprising a first source of fluid in  
 10 communication with said first fluid driven actuator for actuating said female form key  
~~toward said male form key, said first source of fluid in communication with said second~~  
 fluid driven actuator for actuating said male form key toward said female form key.

3. The mold claimed in claim 1 further comprising a timer for retracting said  
 15 first and second fluid driven actuators upon a predetermined period of time after actuation  
 of said first and second fluid driven actuators.

4. The mold claimed in claim 1 wherein said first and second fluid driven  
 actuators are pneumatic.

20 5. The mold claimed in claim 1 wherein said first and second fluid driven  
 actuators are hydraulic.

6. A mold for thermoforming undercuts into foam parts, comprising:  
 25 a male plug, said male plug includes a female form key moveably mounted  
 thereon, and a first fluid actuated piston connected to said female form key for moving  
 said female form key relative to said male plug, and  
 a female cavity, said female cavity includes a male form key moveably mounted  
 thereon, and a second fluid actuated piston connected to said male form key for moving  
 30 said male form key relative to said female cavity and toward said female form key.

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11. The method of forming a reverse draft in a thermoformed foam part claimed in claim 8 wherein said first and second fluid driven actuators each includes a piston with a first side and a second side and said step of withdrawing said female form key and said male form key comprises communicating pressurized fluid to said second  
5 sides of said pistons and venting said first sides of said pistons.

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